

Date: Thursday, 28/05/2009 9:11:30 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HANDLE WELDMENT		
Job Number	: 48231					
Estimate Number	: 10333					
P.O. Number	:			Part Number	: D2530 BK	
This Issue	: 28/05/2009		S.O. No. :	Drawing Number	: D2530 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: //		Type	Drawing Revision	: B	
Previous Run	: 46579			Material	:	
Written By	:			Due Date	: 12/06/2009	
Checked & Approved By	: JU 09-05-28			Qty:	10	Um: Each
Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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(10X)

Comment: Qty.: 3.0602 f(s)/Unit Total : 30.6023 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: M 111619

M 111619/09/06/02

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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(10X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP 09/06/02 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	D2534	Lock Plate
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(10)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	H47176-204 SP

09.06.08

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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(10)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

09.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:30 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 48231

Part Number: D2530

Job Number:



Seq. #: Machine Or Operation:

Description :

2-Deburr

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Pl09-06-09*

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S0166109*

*410*

8.0 POWDER COATING POWDER COATING



*M109091*

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 10:00 am

OVEN TEMPERATURE: 320°f

FINISH TIME: 16:30 Am

*9/01-06-13*

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BL 09-06-17*

*10*

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 506

*8809/06/17*

11.0 QC21 FINAL INSPECTION/W/O RELEASE



*09/06/18*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-06-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

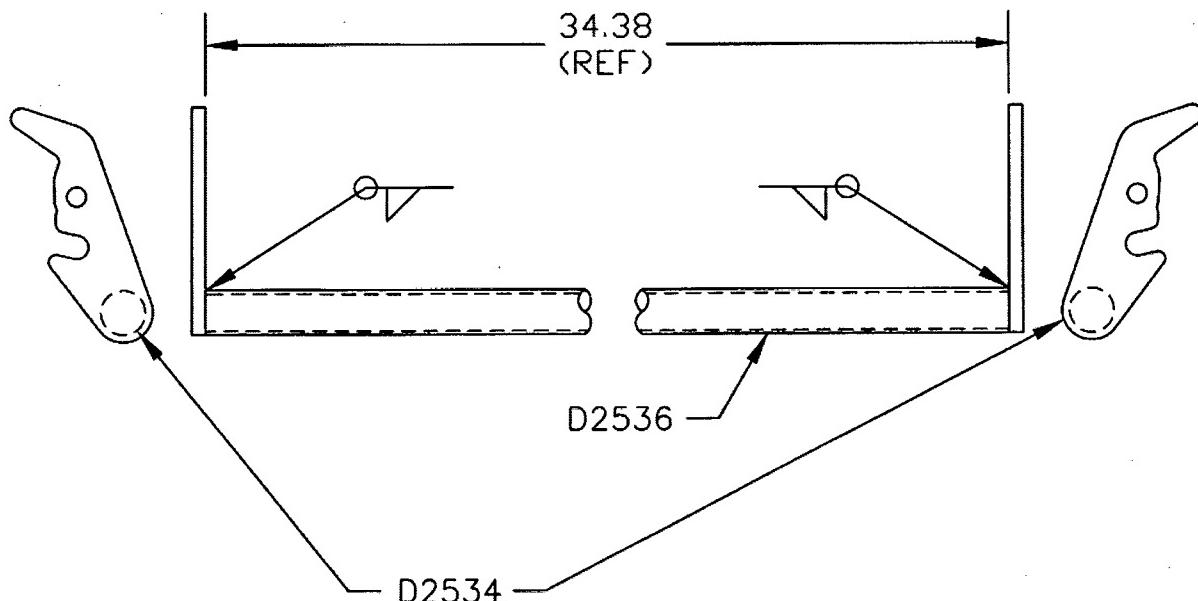
NOTE: Date & initial all entries

**DART**

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE WELDMENT		SCALE
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

**RELEASED**04.12.16 *[initials]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

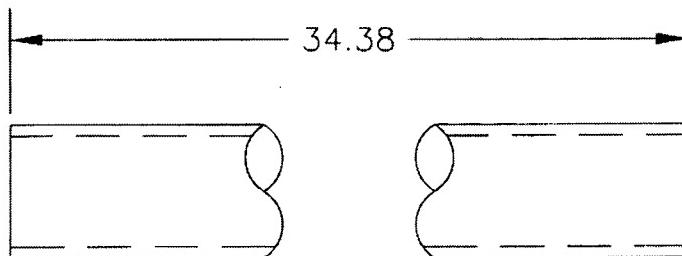
WORK ORDER

NO. 40231

**DART**

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2536	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE	SCALE NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

44-12-16  
04.12.16 *[Signature]*

**REFERENCE ONLY***48231*D2536 HANDLE

- 1) MATERIAL: AISI 304/316 SS  $\phi 0.75$  X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED